












Date: Tuesday, 07/10/2008 10:16:21 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 42486		
Estimate Number	: 13313		
P.O. Number	:	Part Number	: D37943
This Issue	: 07/10/2008 S.O. No. :	Drawing Number	: D3794 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 39713	Material	:
Written By	:	Due Date	: 20/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUD 08.10.07</u>		
Comment	: Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	MNEO60S063	NEOPRENE SHEET 0.063	
			
Comment: Qty.: 1.3469 sf(s)/Unit Total: 16.1633 sf(s) NEOPRENE SHEET 0.063 Batch: <u>108817</u> <u>HB 8-10-14</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3794 Dwg Rev: <u>A</u> <u>HB 8-10-14</u> Prog Rev: <u>A</u> 2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-10-14</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>S 08/10/14</u> <u>(14)</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>FP 18</u> <u>18</u> <u>08/10/15</u> <u>14</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 42486

Part Number: D37943

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/15 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42486
Description: Gasket		Part Number: D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.19	*			
0.300 x 0.300	+/-0.010	302 x 302	*			
1.88	+/-0.030	1.894	*			
4.281	+/-0.010	4.285	*			
6.44	+/-0.030	6.37	*			
6.00	+/-0.030	6.00	*			
6.75	+/-0.030	6.75	*			
2.00	+/-0.030	2.00	*			
4.75	+/-0.030	4.755	*			
9.50	+/-0.030	9.50	*			
14.25	+/-0.030	14.25	*			
17.75	+/-0.030	17.75	*			
26.74	+/-0.030	26.73	*			
29.23	+/-0.030	29.23	*			

Measured by: JB	Audited by: S	Prototype Approval: N/A
Date: 8-10-14	Date: 08/10/14	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	

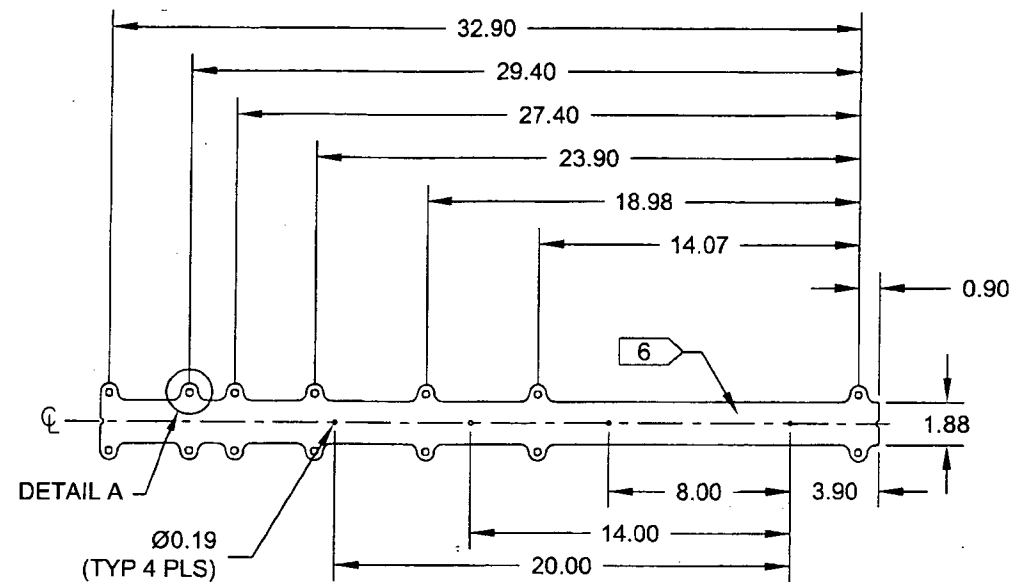
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

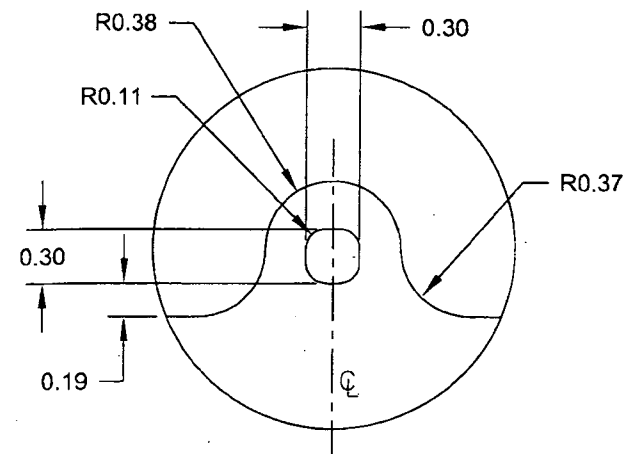
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

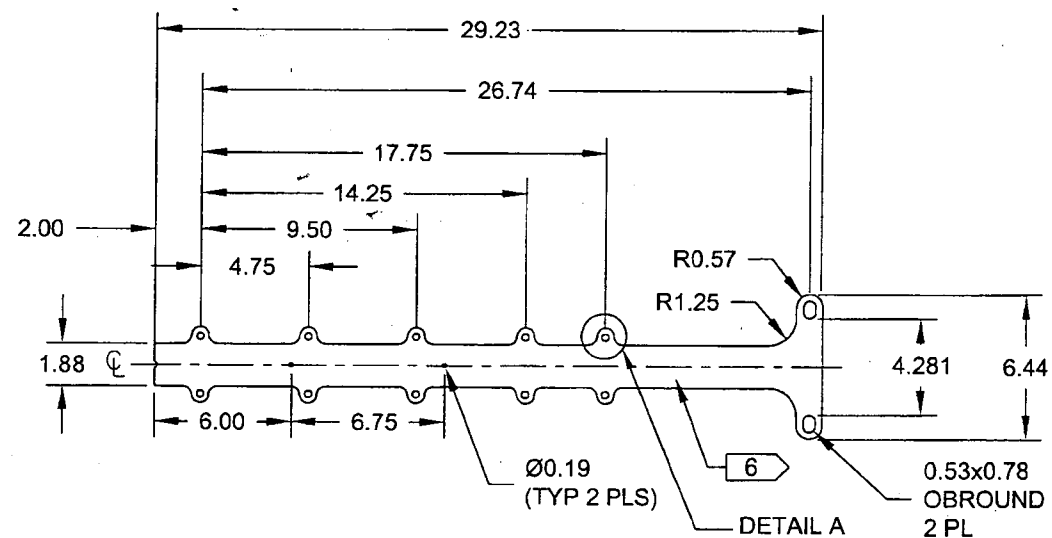
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

RELEASED
08-05-14
COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120480

A	NEW ISSUE	PH	08.05.14
REV.		DESCRIPTION	BY DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	DS	D3794	SHEET 1 OF 1
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	GASKET	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			